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D5610-1TRN Job Sheet 182526



Part No: D5610-1TRN

Job Qty: 1 ea

Part Name: EC130 Aft Crosstube Turning Detail



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/27/18

Job Tracking No:

Due Date: 9/4/18

Created By: Jesse White

Type: Stock

Description:

Note: D5610 REV.A8 IPP REV:A 18.07.04 NEW ISSUE DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		9/4/18	0.00	0.00	Start Up Crosstubes-1		MD
100	Mori Seiki	1 pcs		9/4/18	4.40	2.38	Mori Seiki TL-40		MD
110	QC	1 pcs		9/4/18	0.00	0.00	QC2-1		MD
120	Mori Seiki	1 pcs		9/4/18	0.00	2.38	Mori Seiki TL-40		MD
130	QC	1 pcs		9/4/18	0.00	0.00	QC2-1		MD
140	QC	1 pcs		9/4/18	0.00	0.00	QC8		GP 2018-09-12
145	Crosstubes	1 pcs		9/4/18	0.00	0.68	Crosstubes-1		BB
150	HandFXtube	1 pcs		9/4/18	0.00	1.00	Crosstubes-3		GP 18/09/12
160	QC	1 pcs		9/4/18	0.00	0.00	QC7-1		GP 2018-11-24
170	Packaging	1 pcs		9/4/18	0.00	0.00	Packaging3-1		DP7
180	QC21-SA	1 Ea		9/4/18	0.00	0.00	QC21		21 NOV 21 2018

Part Op 100 - 1- Fill tube with sand & install plugs 2- Face and chamfer both ends as per Folio FC197 3- Turn first taper section on Descriptions: both side

120 - 1- Turn second taper on both side 2- Scribe part # and batch # using vibrating stylus on the cuff as per Dwg D5610-TRN

145 - GRIND ONLY TRANSITION LINES SMOOTH LONGITUDE WAY.

150 - 1- handfinish X-TUBE INSIDE AND OUT

170 - LOCATION : LG014

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6030-140	Tube, Seamless	1 Ea (1 ea)	90-Start up Operation	

5078768

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D6030-140	1	10	0

Part Specifications

Specifications could not be found.



Container No: S109069



Part: D5610-1TRN

Job No: 182526

Serial No/Batch: S109069

Revision: A8

Inspector:

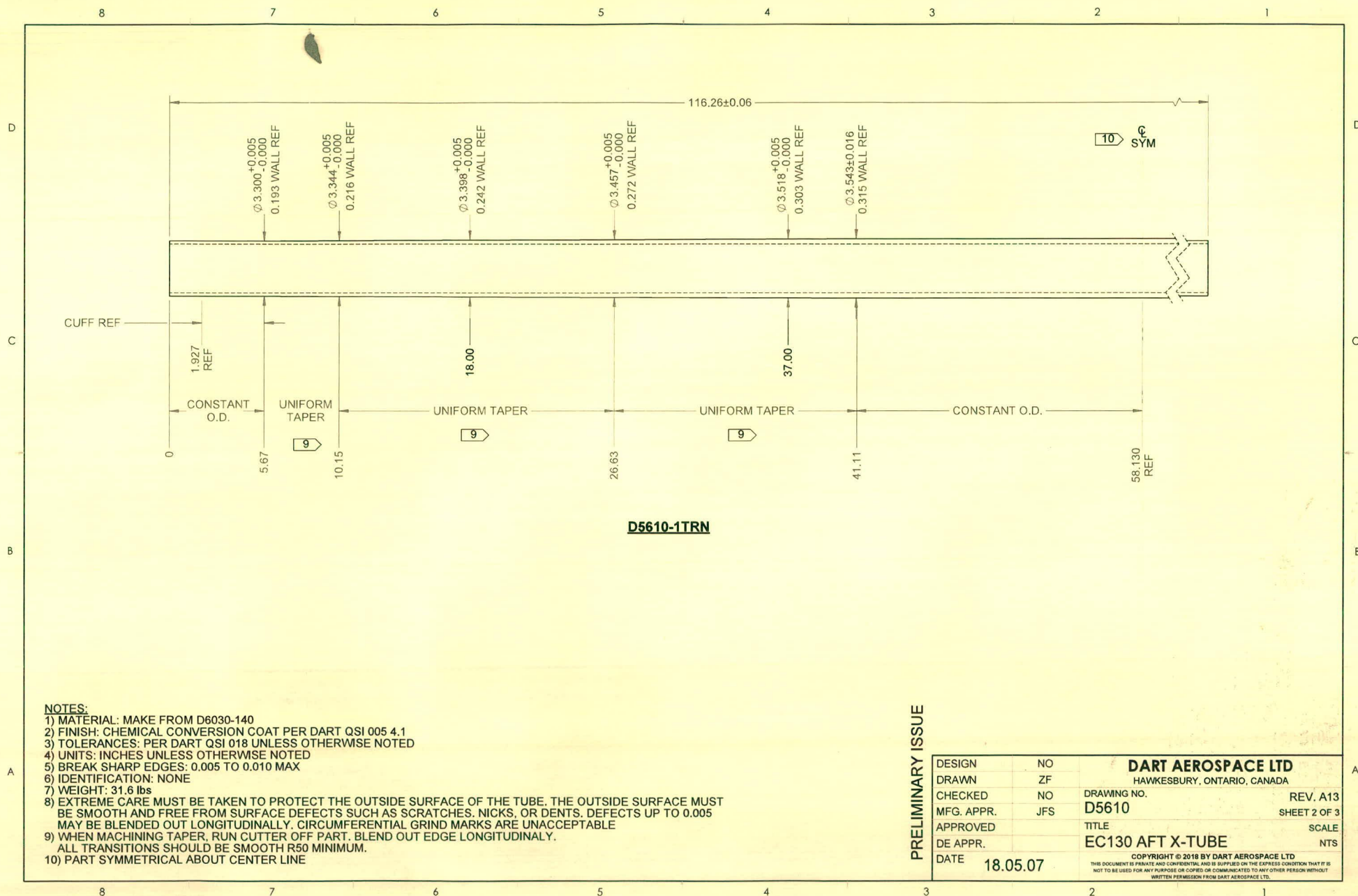
Exp Date:

Instructions:

Dart Aerospace Ltd.
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Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 09/10/18

8705 1-0107



NOTES:

- 1) MATERIAL: MAKE FROM D6030-140
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 31.6 lbs
- 8) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005 MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE
- 9) WHEN MACHINING TAPER, RUN CUTTER OFF PART. BLEND OUT EDGE LONGITUDINALLY.
- 10) PART SYMMETRICAL ABOUT CENTER LINE

PRELIMINARY ISSUE

DESIGN	NO	DART AEROSPACE LTD	
DRAWN	ZF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	NO	DRAWING NO.	REV. A13
MFG. APPR.	JFS	D5610	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		EC130 AFT X-TUBE	NTS
DATE	18.05.07	COPYRIGHT © 2018 BY DART AEROSPACE LTD	
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DART AEROSPACE LTD		Work Order: 182526
Description: Crosstube Assembly		Part Number: D-5610-TBN
Inspection Dwg:	Rev: A	Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

	Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	3.300	+ .005 - .000	3.300	✓		CNC-04	
	3.300	+ .005 - .000	3.301	✓		↓	
	3.344	+ .005 - .000	3.341				under of .003
	3.398	+ .005 - .000	3.398	✓			
	3.457	+ .005 - .000	3.458	✓			
	3.518	+ .005 - .000	3.519	✓			
	3.543	+/- .016	3.540	✓			
	3.543	+/- .016	3.545	✓			
SIDE B	3.300	+ .005 - .000	3.301	✓			CNC-04
	3.300	+ .005 - .000	3.302	✓		↓	
	3.344	+ .005 - .000	3.342				under of .002
	3.398	+ .005 - .000	3.398	✓			
	3.457	+ .005 - .000	3.457	✓			
	3.518	+ .005 - .000	3.518	✓			
	3.543	+/- .016	3.539	✓			
	3.543	+/- .016	3.545	✓			
	116.26	+/- .060	116.270	✓		Tape	

1861

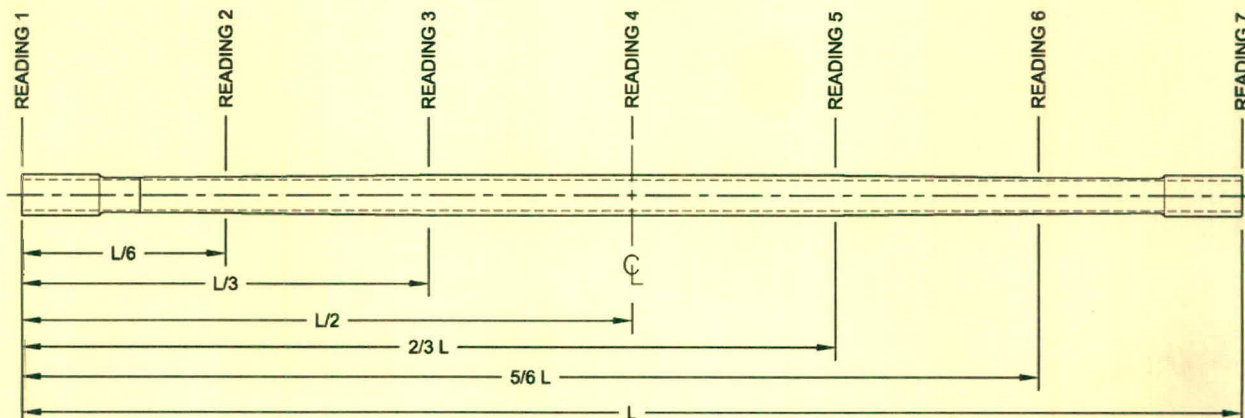
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DART AEROSPACE LTD		Work Order:	182526
Description: Crosstube Assembly		Part Number:	05610-1-TRN
Inspection Dwg:	Rev: A	Page 2 of 2	

WALL THICKNESS MEASUREMENT



Location	WALL THICKNESS MEASUREMENT (IN)				Deviation Δw (max-min)	TOLERANCE
	w1	w2	w3	w4		
READING 1 L= 0"	.181	.203	.198	.176	.027	$\pm 0.030"$ OK 18/09/20
READING 2 L= 19.38	.237	.258	.252	.232	.026	
READING 3 L= 38.77	.301	.314	.311	.298	.016	
READING 4 L= 58.15	.310	.320	.317	.309	.011	
READING 5 L= 77.53	.303	.319	.306	.290	.029	
READING 6 L= 96.92	.243	.258	.246	.232	.026	
READING 7 L= 116.26	.182	.199	.198	.182	.017	

Calibration Result

Actual Block Thickness: 100-400

Sitescan 250 Measured Thickness: 100-400

Measured by:	MD	Audited by:	GP	Preliminary Approval:	
Date:	2018-08-10	Date:	2018-09-12	Date:	

Rev	Date	Change	Revised by	Approved
B	10.04.14	Added preliminary approval	KJ	
C	12.06.01	Wall thickness form added	KJ	

100-100

A

FBT. 100. 100. 100. 100.
V60. 100. 100. 100. 100.
V10. 100. 100. 100. 100.
110. 100. 100. 100. 100.
P60. 100. 100. 100. 100.
V60. 100. 100. 100. 100.
F10. 100. 100. 100. 100.

100-100

100-100
100-100

100-100

100-100